

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services
 Job Number : 47814 -2

Drawing Name : STABILIZER ARM

Time Number : 13523

Job Number :

Issue : 06/08/2008 S.O. No. :

Int Rev. : NC

Issue : 1/1

Previous Run :

Issued By :

Checked & Approved By :

Comment :

Type : SMALL / MED FAB

Part Number : PB674300157

Drawing Number : B6743001 P.13

Project Number : N/A

Drawing Revision : B1

Material :

Due Date : 13/08/2008

Qty:

5 Um:

Each

08-08-06

Est Rev:A 08-07-25 new issue DD verified by:ec

Additional Product

Job Number:



Seq. #:

Machine Or Operation:

Description :

1.0

PB6743001111

Tube End Plate



Comment: Qty.: 1.0000 Each(s)/Unit Total: 5.0000 Each(s)

Tube End Plate

batch: B40013 ✓

SP 08-08-07

(8x)

2.0

PB6743001107

Tube Arm



Comment: Qty.: 1.0000 Each(s)/Unit Total: 5.0000 Each(s)

Tube Arm

batch: 41011 ✓

SP 08-08-07

(8x)

3.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1
 1-Weld assembly as per dwg PB67-43001

SP 08-08-07

(8x)

4.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

S 08/08/07

5.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

08-08-07

6.0

PB6743001109

Male Eye



Comment: Qty.: 1.0000 Each(s)/Unit Total: 5.0000 Each(s)

Male Eye

batch: B41415

08-09-12

Form: rprocess

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: STABILIZER ARM

Job Number: 41014

Part Number: PB674300157

Job Number:



Seq. #: Machine Or Operation: Description:

7.0 240107 SPRING SLOTTED PIN



Comment: Qty.: 2.0000 Each(s)/Unit Total: 10.0000 Each(s)

SPRING SLOTTED PIN

batch: 17850

FL 08-09-12 3

8.0 SMALL FAB 1 SMALL & MEDIUM FAB RESOURCE 1



Comment: 1- line drill -107 and -109 using existing pilot hole of -107 as per dwg
2- install spring pin

FL 08-09-12 3

9.0 QC5 INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

SO 08/02/14 48

10.0 POWDER COATING POWDER COATING



Comment: POWDER COATING

Powder Coat Green Sandtex (Ref: 4.3.5.8) as per QSI 005 4.3

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

*10:00
320°F
10:30*

M-F 08/09/13

11.0 QC3 INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

FL 08/09/15 (3)

12.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: *cube PNC's stage*

FL 08/10 (3)

13.0 QC21 FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Completion



MF 08-09-15

RELEASED
JUL 21 1964



100-1000